Work Order ID 116105

Friday, April 04, 2014 2:03:32 PM

116105

Item ID: D4003-047 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fuel Pump Inlet Pipe

Start Date: 4/15/14 **Start Qty:** 2.00 *2*

Required Date: 4/15/14 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 14-04-10 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4003 / A									
100		0.00							
100						2		FF	14-07-16
Small Fab	**Memo**	0.00							
Small Fab	1- Cut tube 12.00" long								
	2- Bend as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110						2			
QC	**Memo**	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						2	MGM 7-11		
HandFinish	**Memo**	0.00							
Hand Finishing									

DAS 27 9-89 14/7/11

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4003-047 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fuel Pump Inlet Pipe
Start Date: 4/15/14 **Start Qty:** 2.00 *2* **Cust Item ID:**
Required Date: 4/15/14 **Req'd Qty:** 2.00 *2* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
161		0.00				2 FF	14-07-14		
161									
Small Fab	**Memo**	0.00							
Small Fab	1- intall sleeve and nut								
	2-flare ends as per dwg								
162	QC5- Inspect part completeness to step on W/O	0.00 DAS 21 9-89				2			
162									
QC	**Memo**	0.00 M-7-14							
Quality Control									
170	Identify as per dwg & Stock Location: 7209	0.00				2X	14-7-14		DAS 26 9-89
170									
Packaging	**Memo**	0.00							
Packaging									

14-7-14

DQA: _____ Date: _____

DART AEROSPACE

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Scrap ☐
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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

Friday, April 04, 2014 2:03:32 PM

Work Order ID: 116105 *116105*

Parent Item: D4003-047 *D4003-047*

Parent Item Name: Fuel Pump Inlet Pipe

Start Date: 4/15/14 **Required Date:** 4/15/14

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP rev A 10.01.12 new issue prelim EC verified by:DD IPP Rev B 10.05.13 ecn 10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-6D		Purchased	No			161	Each	45.0000	2	4			
AN818-6D									**		FF	14-07-14	
Nut													
				Location			**Loc Qty**		**Loc Code**				
				ST348			45						
					M126180		15			3			
					M128306		30			1			
M6061T6T0.375W.035		Purchased	No			100	f	102.8387	0.98	1.96			
M6061T6T0.375W.035									**		FF	14-07-10	
6061-T6 RD Tube .375 x.035W													
				Location			**Loc Qty**		**Loc Code**				
				MAT014			102.8387						
					112652		11			0.98			
					124491		91.8387			0.98			
MS20819-6D		Purchased	No			161	Each	20.0000	2	4			
MS20819-6D									**		FF	14-07-14	
Sleeve													
				Location			**Loc Qty**		**Loc Code**				
				ST312	129499		20			4			
					m128401		20						

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Doc/Data	☐									
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD

Description: Fuel Pump Inlet Pipe Work Order: 116105

Inspection Drawing: D4003 Rev: A Part Number: D4003-047

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.77	±0.030	8.77	✓		S-Fab-07	
3.21	"	3.21	✓		S-Fab-08	
4.37	"	4.37	✓		S-Fab-08	
1.60	"	1.60	✓		S-Fab-08	
3.96	"	3.96	✓		S-Fab-08	
134°	1°	134°	✓		S-Fab-05	
44°	1°	44°	✓		S-Fab-05	

Measured by: FF	Checked By: ~~DAS~~ 30 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*)
Date 14-07-11	Date 14/07/11	Date 14/7/11	Date